

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	BEARPAW KIT (19"X24")
Job Number	:	32012			
Estimate Number	:	10323			
P.O. Number	:	N/A	Part Number	:	D206559013
This Issue	:	4/23/2007 S.O. No. : N/A	Drawing Number	:	D2432 REV F3
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : MACHINED PARTS	Drawing Revision	:	F3
Previous Run	:	30801	Material	:	N/A
Written By	:	[Signature]	Due Date	:	5/30/2007 Qty: 5 Um: Each
Checked & Approved By	:	[Signature] 04.02.23			
Comment	:	Est Rev: 04.02.17 Blank size changed KJ/JLM			
		Est Rev:K 07-01-02 Was K10008 JLM			

Job Number:

1.0 DC DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------

Comment: Qty.: 6.8250 sf(s)/Unit Total : 34.1250 sf(s)
blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
Material: Black UHMW 1"
(MUHMWB10)
Batch: M105862

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Debut

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 32012

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8/5/10/22 (5)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

HHH 7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 12.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

B30872

SP

HHH 8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

B32015

n/a

SP

HHH 9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

B33937

SP

HHH 10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer

B32025

7/10/23 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 32012

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : 2.0830 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion

B3471A

SP

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M104746

SP

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M103691

SP

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M105426

SP

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M104683

M105054

7/16/23 SP SX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 32012

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 07/10/23 (5) Kits

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location: A

07/11/23 (5)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/24 (5)

Job Completion



U 07-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32012
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.055X45°	—			
B	5.500	+/-0.030	5.501	—			
C	0.200	+/-0.030	0.203	—			SAME AS
D	0.25 x 45°	+/-0.030	0.249X45°	—			
E	R0.250	+/-0.030	R0.250	—			
F	0.250	+/-0.010	0.243	—			
G	0.625	+/-0.030	0.610	—			
H	0.375	+/-0.010	0.384	—			
I	0.950	+0.030/0.010	0.947	—			W/O 32768
J	19.000	+/-0.030	19.000	—			
K	3.14	+/-0.030	3.110	—			
L	3.28	+/-0.030	3.310	—			S.F. 01/10/22
M	Ø0.260	+0.005/-0.000	Ø0.260	—			
N	Ø0.93	+/-0.030	Ø0.927	—			
O	0.30	+0.030/-0.000	0.310	—			
P	23.750	+/-0.030	23.750	—			
Q	7.375	+/-0.030	7.375	—			
R	4.250	+/-0.010	4.250	—			
S	2.000	+/-0.030	2.000	—			
T	9.000	+/-0.010	9.000	—			
U	9.000	+/-0.010	9.000	—			
V	0.375	+/-0.010	0.380	—			

Measured by:	<i>gmk</i>	Audited by:	J.L	Prototype Approval:	N/A
Date:	07/10/19	Date:	07/10/19	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF <i>af</i>	<i>af</i>



RELEASED
98.06.17 KB

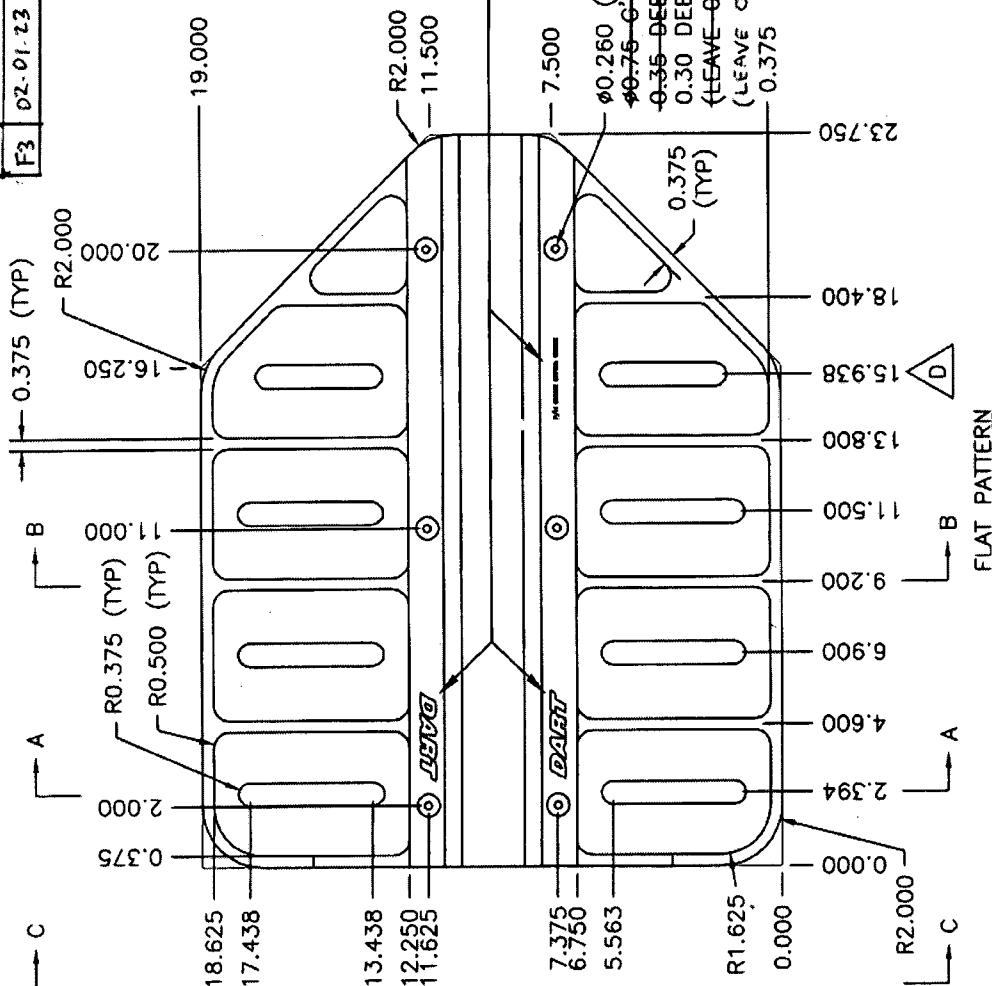
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MA	APPROVED SA	DRAWING NO. D2432	REV. F SHEET 1 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:6
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75
F3	02.01.23	CLARIFY BORE DIMS & RF

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE DEOs

9143	



BEND AFTER MACHINING
(D2432B ONLY)



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

SHOP COPY
RETURN
ENGINEERING

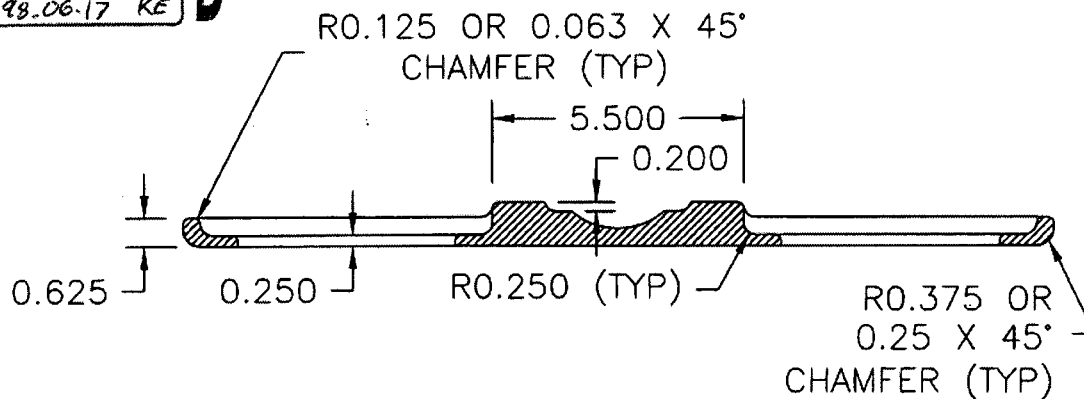
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

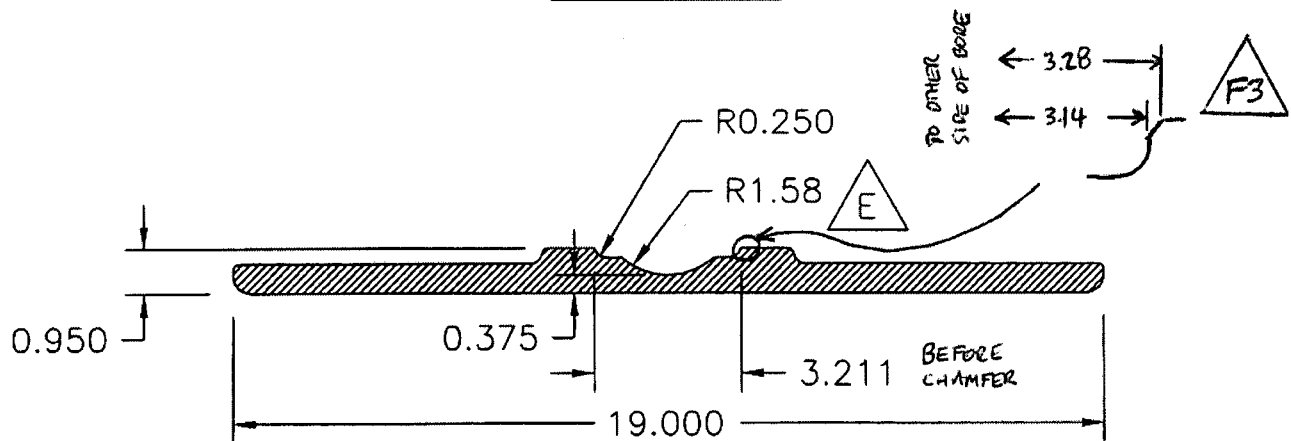


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

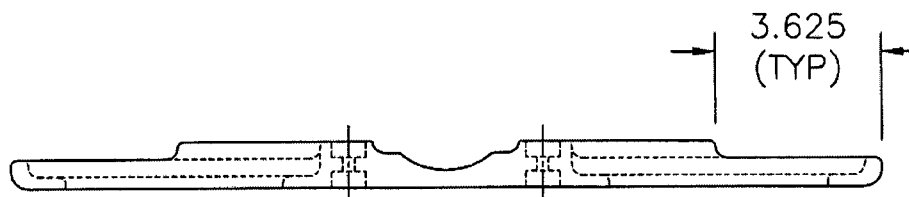
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32012